

Work Order ID 140502

140502

January 07, 2016 10:50:43 AM

Page 1

Ship Jan 14.

Item ID: D412-760-111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Cabin Wall & Pylon Protector
 Start Date: 1/7/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/14/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SLU Date: 20160107 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN D412-760	G								
100	Document Control	0.00							

100

DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D412-760-111 CHG002

DAS
27
9-89

JAN 12 2016

110	Pick Kit	0.00							
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110

Packaging Memo 0.00
 Packaging

DAS
6
9-89

DAS

28

JAN 08 2016

120	QC4- 100% Inspect kits for completeness	0.00							
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120

QC Memo 0.00
 Quality Control

DAS
27
9-89

JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

Work Order ID 140502***140502***

Page 2

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Item ID: D412-760-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 1/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/14/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-760-011
Location:FG040

fg040

BAS
27
0.00

JAN 12 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

mcs

JAN 12 2016

mcs

JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

January 07, 2016 10:50:48 AM

Page 1

Work Order ID: 140502

140502

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 1/7/2016

Required Date: 1/14/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	DAS 6 9-89	DAS 28 9-89
D3933-1 *D3933-1* Aft Wall Protector		Manufactured	No			110	Each	0.0000	1	1				DAS 6 9-89	DAS 28 9-89
D3933-2 *D3933-2* Aft Wall Protector, RH		Manufactured	No			110	Each	0.0000	1	1				DAS 6 9-89	DAS 28 9-89
D3935-1 *D3935-1* Pylon Wall Protector, LH		Manufactured	No			110	Each	0.0000	1	1				DAS 6 9-89	DAS 28 9-89
D3935-2 *D3935-2* Pylon Wall		Manufactured	No			110	Each	0.0000	1	1				DAS 6 9-89	DAS 28 9-89
D3942-1 *D3942-1* Angle		Manufactured	No			110	Each	24.0000	14	14				DAS 6 9-89	DAS 28 9-89
D3942-3 *D3942-3* Clip		Manufactured	No			110	Each	16.0000	10	10				DAS 6 9-89	DAS 28 9-89
Location ST060 136343 Loc Qty 24 24 Loc Code 															
Location ST060 136345 Loc Qty 16 16 Loc Code 															

DAS
6
9-89
JAN 08 2016

Picklist Print

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Page 2

Work Order ID: 140502

140502

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 1/7/2016

Required Date: 1/14/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-10

Purchased

No

110

Each

72.0000

4

4

DAS

6

DAS

28

9-89

MS27039-4-10

Screw

Location

Loc Qty

Loc Code

ST279

72

m131885

72

MS27039-4-14

Purchased

No

110

Each

46.0000

6

6

DAS

6

DAS

28

9-89

MS27039-4-14

SCREW

Location

Loc Qty

Loc Code

CA

13

m129682

13

ST279

33

m131197

33

MS27039-5-08

Purchased

No

110

Each

14.0000

6

6

DAS

6

DAS

28

9-89

MS27039-5-08

Screw

Location

Loc Qty

Loc Code

ST279

14

m131896

14

MS27039-5-12

Purchased

No

110

Each

33.0000

8

8

DAS

6

DAS

28

9-89

MS27039-5-12

Screw

Location

Loc Qty

Loc Code

ST278

33

m131886

13

m133694

20

DAS

6

9-89

JAN 08 2016

DART AEROSPACE LTD.

REFERENCE ONLY

BAS
27
S-09

IIN-D412-760

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Qty -111	Qty -113	Part Number	Description
X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	1	D3935-4	RH PYLON PROTECTOR
14	14	D3942-1	ANGLE
10	10	D3942-3	CLIP
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty -211	Qty -213	Qty -215	Qty -217	Part Number	Description
X				D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			X	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
36	7	8		D3628-1	CUPPED WASHER
			43	D3628-5	CUPPED WASHER
1				D3876-1	RH FORWARD WALL PROTECTOR
1				D3876-3	FORWARD WALL PROTECTOR
1				D3876-5	LH WALL PROTECTOR
1				D3876-7	AFT WALL PROTECTOR
1				D3876-9	RH AFT WALL PROTECTOR
1		1		D3876-11	FLOOR PROTECTOR
1				D3876-13	DOOR PROTECTOR
1		1		D3952-1	PLACARD
			1	D3952-3	PLACARD
	1			D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
			1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
36		8	36	80-004-2-6	INSERT
	7		7	80-004-2-8	INSERT
36		8	36	MS27039-1-04	SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

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Revision: G
Date: 13.01.03